

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001971**Date Inspected:** 16-Apr-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 2300**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

CWI Name:	N/A	CWI Present:	Yes	No
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use: Yes No N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed: Yes No N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up: Yes No N/A
Approved Drawings:	Yes	No	N/A	Approved WPS: Yes No N/A
				Delayed / Cancelled: Yes No N/A
Bridge No:	34-0006	Component:	Tower and OBG Fabrication	

Summary of Items Observed:

Caltrans Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai, China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. The QA Inspector observed the following:

Orthotropic Box Girder (OBG) and Tower Fabrication:

Bay 1

The QA Inspector performed ultrasonic inspections of OBG Side plate complete joint penetration groove welds:

SP527-001-043, SP527-001-050, SP527-001-052, SP475-001-043, SP475-001-050, SP475-001-044, SP475-001-052, SP607-001-037, SP607-001-043, SP607-001-038, SP607-001-045, SP753-001-037, SP753-001-043, SP753-001-038, SP753-001-045, SP515-001-037, SP515-001-043, SP515-001-045, SP515-001-047.

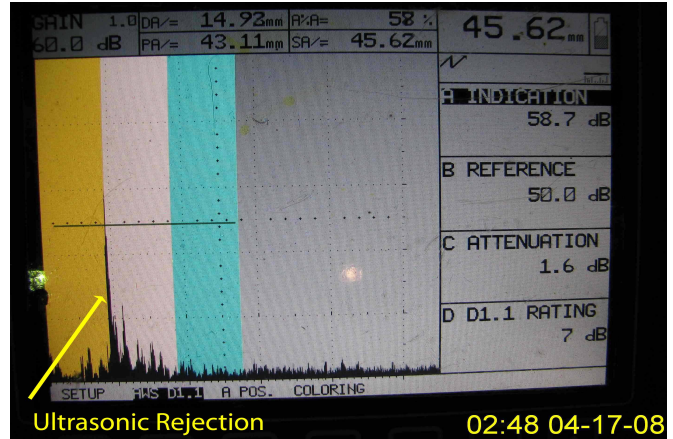
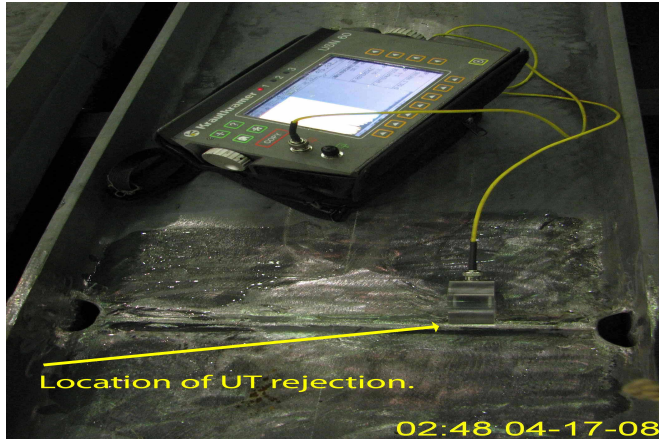
SP527-001-044, SP515-001-038 and items observed appear to comply with project specifications.

Welds SP515-001-047 and SP515-001-049 both have class "A" indications that do not meet the project specifications.

See the TL-6027 "Ultrasonic Test Report" dated today and the photographs below for additional information.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)



Summary of Conversations:

See above for summary of conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Patrick Lowry (858) 344-2712, who represents the Office of Structural Materials for your project.

Inspected By:	Dawson,Paul
Reviewed By:	Carreon,Albert

Quality Assurance Inspector
QA Reviewer
